



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4880-1
Job Sheet 166320



Part No: D4880-1

Job Qty: 4 ea

Part Name: Strut



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV C SHEET 5 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D4880-1 Strut	DWG REV C SHEET 5 IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM		0.000	
M174PH-H900R0.750 17-4 SS H900 Round Bar 0.750"			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	4 Ea	10/30/17	0.00	0.00	Start up container	
100	Doosan	4 pcs	10/31/17	0.20	5.88	Doosan	
110	QC	4 pcs	10/31/17	0.00	0.00	QC2	
120	QC	4 pcs	10/31/17	0.00	0.00	QC8	
130	Outsource	4 pcs	10/31/17	0.00	0.00	Outsource2	
140	Packaging	4 pcs	10/31/17	0.00	0.00	Packaging2	
150	QC	4 pcs	10/31/17	0.00	0.00	QC5	
160	Packaging	4 pcs	10/31/17	0.00	0.00	Packaging3	
170	QC21-SA	4 Ea	10/31/17	0.00	0.00	QC21	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M174PH-H900R0.750	3	0	0	0

Part Specifications

Specifications could not be found.

Plex 10/2/17 2:04 PM Dart.lajeunesse.marie

P038327

DART
AEROSPACE
S010265

Dart Aerospace Ltd.

1270 Aberdeen Street
Hawkesbury, ON K64 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com



Strut

PART NO: D4880-1
Revision:
Operation: QC21-SA
Change No:

Mfg Date: 11/15/17
Job No: 166320

Friday, September 15, 2017 9:27:59 AM

166320

Page 1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Strut

Stop *NS2*

Start Date: 9/15/2017 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 9/22/2017 Req'd Qty: 4.00

4

Customer:

Reference: S/O 132346

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4880	C

100

1.07

100

DOOSAN LATHE

Doosan

Memo

2.14

Doosan Lathe

1- Turn as per Folio FB245

Rev: N/A & Dwg D4880 Rev: C

2- Deburrr

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.04

Quality Control

Friday, September 15, 2017 9:27:59 AM

Page 2

Packaging

4 0 ~~17-10-30~~

4x SDA-11-15

Friday, September 15, 2017 9:27:59 AM

Page 3

Setup Start *NS1*

Stop *NS2*

4

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

**Insp.
Stamp**

0.00

0.08

Memo

Quality Control

0.00

0.04

Packaging

Packaging

0.00

0.40

QC

Quality Control

Picklist Print

Page 1

Friday, September 15, 2017 9:27:59 AM

Work Order ID: 166320

166320

Parent Item: D4880-1

D4880-1

Parent Item Name: Strut

Start Date: 9/15/2017

Required Date: 9/22/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 13.12.17 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H900R0.750		Purchased			No	100	f	6.5132	0.76	3.2			

M174PH-H900R0 750

17-4 SS H900 ROUND BAR 0.750"

JK 17-10-21

Location

Loc Qty

Loc Code

MAT030

6.5131576

m137243

0.77

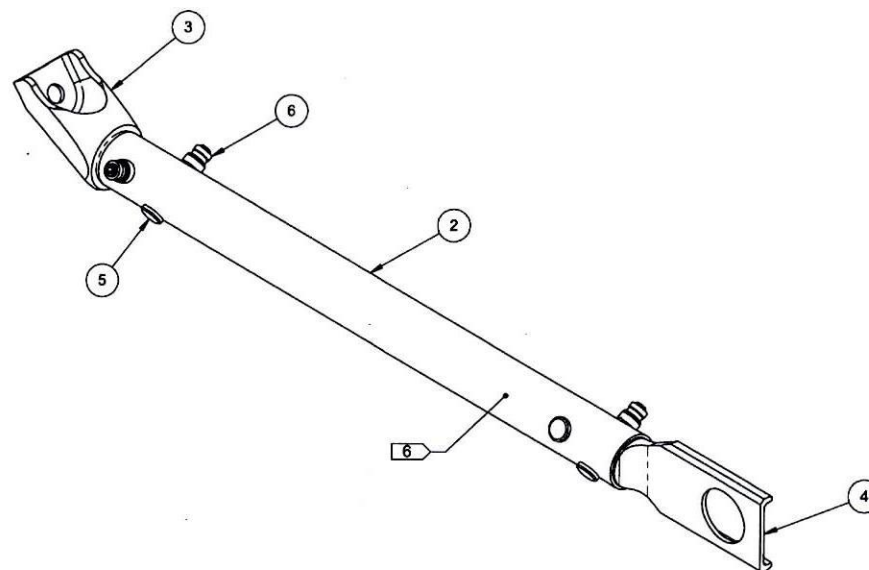
m138005

5.7431576

(FM138005 X6)

** 3.36*

ITEM	QTY. -041	P/N	DESCRIPTION
1	X	D4880-041	FWD LEG ASSEMBLY, LH
2	1	D4880-1	STRUT
3	1	D4883-7	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 166320

SEP 15 2017

RELEASED
2014-07-03

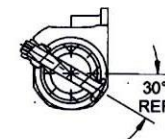
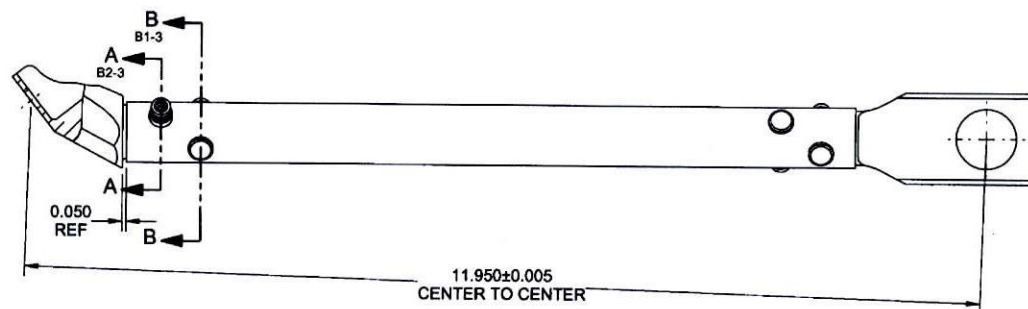
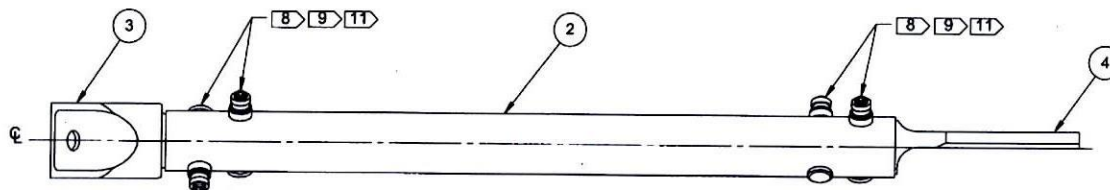
D4880-041 FWD LEG ASSEMBLY, LH
(EQUIVALENT TO BELL P/N 206-062-101-101)

NOTES:

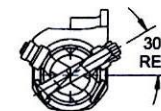
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-7 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9971
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9971
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

C	HL32PB5-12 WAS HL20PB5-12 (ZN D4-1, D4-3); REVISE NOTE 8) (ZN A8-5); ADD "FWD" (ZN B4-1, B4-2, B4-3, B4-4)	RF	14.06.24
B	REVISE NOTES 8), 7) & 9) (ZN A8-1, A8-3); ADDED BELL P/N	RF	14.04.08
A	NEW ISSUE	RF	13.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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APPROVED



SECTION A-A C7-3
2 PL, SIMILAR



SECTION B-B C7-3
2 PL

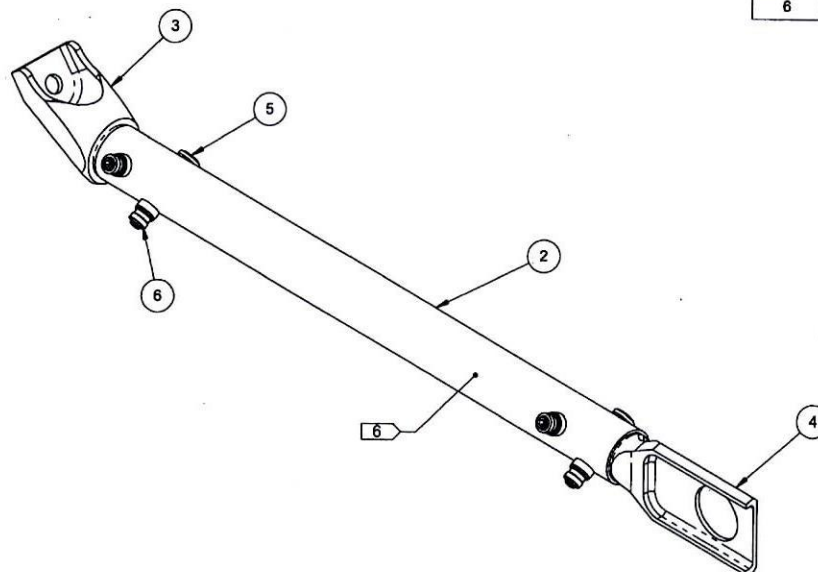
D4880-041 FWD LEG ASSEMBLY, LH
AUXILIARY VIEW

RELEASED
2014-07-07
MD

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO. D4880	REV. C
MFG. APPR.	JLM	SHEET 2 OF 5	
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	LEG ASSEMBLY	NTS
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ITEM	QTY. -042	P/N	DESCRIPTION
1	X	D4880-042	FWD LEG ASSEMBLY, RH
2	1	D4880-1	STRUT
3	1	D4883-5	END FITTING
4	1	D4884-1	END FITTING, EYE
5	4	HL32PB5-12	HI-LOK PIN
6	4	HL86-5	HI-LOK COLLAR



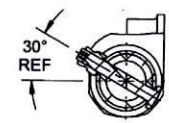
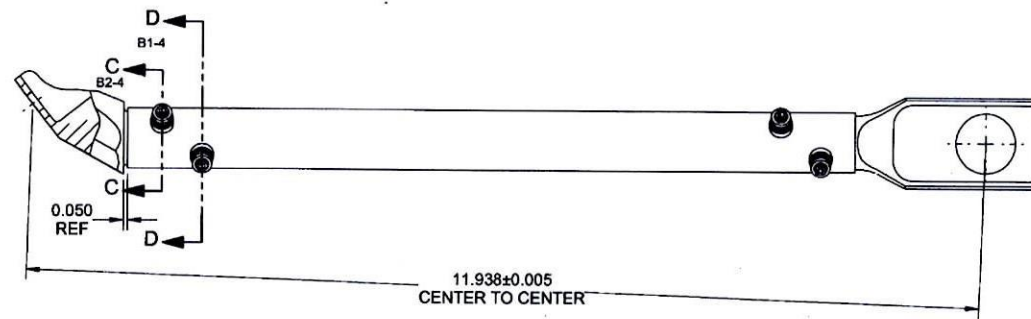
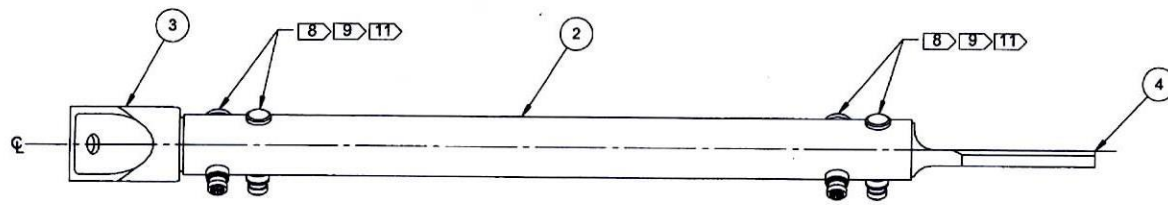
D4880-042 FWD LEG ASSEMBLY, RH
(EQUIVALENT TO BELL P/N 206-062-101-102)

NOTES:

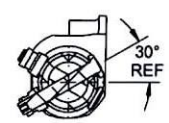
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.8
- 7) WEIGHT: 0.69 lbs
- 8) ALIGN PILOT HOLES IN D4880-1 WITH PILOT HOLES IN D4883-5 & D4884-1.
DRILL OUT EACH HOLE USING A P/N 13-SB65 (0.125) PILOTED DRILL.
REAM EACH HOLE USING P/N 31-219 (Ø0.1610) REAMER, USING DART TOOL SETUP DT9972
- 9) INSTALL PIN/COLLAR AND END FITTING WITH HYSOL EA934NA OR MAGNOBOND 6398 ADHESIVE WHILE STILL WET
- 10) ASSEMBLE PER DART TOOL DT9972
- 11) INSTALL HL32PB5-12 HI-LOK IN ORIENTATION SHOWN

RELEASED
2014-07-07

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	VS		
	CHECKED	HS	DRAWING NO. D4880	REV. C
	MFG. APPR.	JLM	SHEET 3 OF 5	
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	LEG ASSEMBLY	NTS
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SECTION C-C C7-4
2 PL



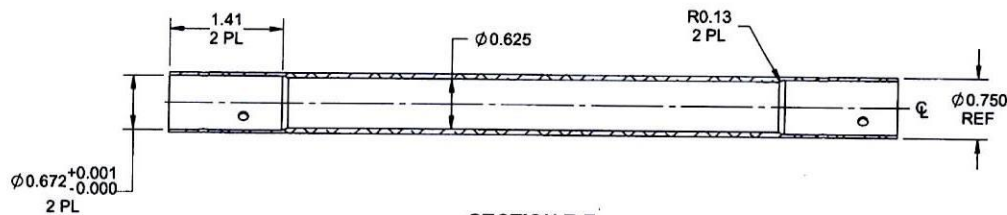
SECTION D-D C7-4
2 PL

D4880-042 FWD LEG ASSEMBLY, RH
AUXILIARY VIEW

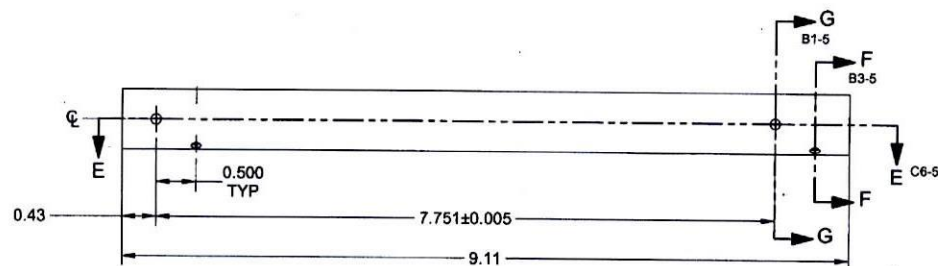
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2014-07-07

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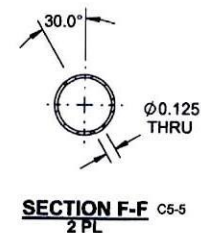
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO.	REV. C
MFG. APPR.	JLM	D4880	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
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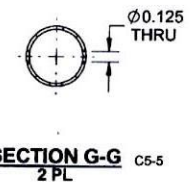
SECTION E-E B4-5



D4880-1 STRUT



SECTION F-F C5-5



SECTION G-G C5-5

NOTES:

- 1) MATERIAL: 17-4 PH/S17400/TYPE 630 SS ROUND BAR, H900 CONDITION
PER AMS 5643/ASTM A564
DART SPEC M17-4-R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.6
- 7) WEIGHT: 0.31 lbs
- 8) LIQUID PENETRANT INSPECT PER QSI 038 6.1.1 (ASTM E1417 LEVEL 2)

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	VS		
CHECKED	HS	DRAWING NO. D4880	REV. C
MFG. APPR.	JLM	SHEET 5 OF 5	
APPROVED	HS	TITLE	SCALE
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2014-07-07
WIP



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO038325

Supplier: SKY002-VC
Skyservice
6120 Midfield Road
Mississauga
ON
L5P 1B1 Canada
Phone: 905-678-5636
Fax: 905-678-5841

PO No: PO038325
PO Date: 11/10/17
Due Date: 11/10/17
**Purchase Order
Revision:**
Revision Date:
Ship-To Contact: Baker, Diane
Phone: dbaker@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items												
Line Item	Job	Part	Rev	Description	Item Tax	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	166319	D4883-7	-	End Fitting Outsource process - NDT per QSI038 4.1 Issue P/O: _____ LPI Per ASTM 1417 LEVEL 2 Certificate of conformaty is required.		Firmed	11/10/17	3 pcs	0 pcs	3 pcs	\$76.00/pcs	\$228.00
2	166320	D4880-1	-	Strut		Firmed	11/10/17	4 pcs	0 pcs	4 pcs	\$76.00/pcs	\$304.00
3	164477	D119- 796-141	-	Fwd Crosstube Installation Without Step (No Hardware) *** WEAR LATEX GLOVES WHEN HANDLING CROSSTUBE*** Liquid Penetrant Inspection as per QSI 038Or Issue P/O: _____ LPI as per ASTM 1417 Level 2 Attach copy of NDT results to work order		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$76.00/pcs	\$76.00
4	158989	D350- 748-203	-	AS350 / AS355 Stainless Steel Aft Crosstube ISSUE P/O TO SKY SERVICE: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$76.00/pcs	\$76.00
5	164645	D350- 748-203	-	AS350 / AS355 Stainless Steel Aft Crosstube ISSUE P/O TO SKY SERVICE: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$76.00/pcs	\$76.00
6	164731	D350- 748-103	-	AS350 / AS355 Stainless Steel Fwd Crosstube ISSUE P/O TO SKY SERVICE: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$76.00/pcs	\$76.00
7	157387	D350- 748-103	-	AS350 / AS355 Stainless Steel Fwd Crosstube ISSUE P/O TO SKY SERVICE: _____		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$76.00/pcs	\$76.00
8	162388	D119- 796-241	-	Aft Crosstube Installation Without Step (No Hardware)		Firmed	11/10/17	1 pcs	0 pcs	1 pcs	\$76.00/pcs	\$76.00

**skyservice****Work Order Traveler**
Sky Service F.B.O. Inc.

PO 038325

10105 Ryan Avenue, Dorval, Quebec, H9P 1A2

TCCA AMO 53-89 / EASA 145.7142 / BDA AMO 385

WO #: MWO33970	Customer:	Dept: NDT YUL	Reference: PO038325
Descr:	PN:	S/N:	Qty: 1
Make:	Model:	Reg:	A/C S/N:
TSN:	CSN:	TSO:	
Task: UNSCHEDULED			Sequence: 1

Work Required:

CARRY OUT NDT ON 8 CROSSTUBES , 3 END FITTINGS AND 4 STRUTS AS PER PO038325

3 END FITTINGS , P/N# D4883-7 , J/S# 166319

4 STRUTS , P/N# D4880-1 , J/S# 166320

SPY 11-15

2 STAINLESS STEEL FWD CROSSTUBES , P/N# D350-748-103 , J/S# 157387 , 164731

2 STAINLESS STEEL AFT CROSSTUBES , P/N# D350-748-203 , J/S# 164645 , 158989

2 AFT CROSSTUBES , P/N# D119-796-241 , J/S# 163790 , 162388

2 FWD CROSSTUBES , P/N# D119-796-141 , J/S# 164477 , 165700

Action Taken:						Date:	Initial/Stamp:
LPI C/O IAW ASTM E-1417M-13						NOV 10 2017	
NO CRACK FOUND							
PEN. ZL-56, MPO13600, CLEANER SKC-S MPO13923 , EMU. MPO15896, DEV. MPO11715 , UV LIGHT M-20142							
Description	Location	P/N	Qty	Batch	S/N Off	S/N On	

I certified that the maintenance described above has been performed in accordance with the applicable standard of airworthiness.

Signature:	ACA/SCA Stamp	Date:
Name: RAFIK MELIKIAN		NOV 10 2017